

Date: Wednesday, 11/22/2006 1:39:31 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29647A
Estimate Number : 10452
P.O. Number : *N/A*
This Issue : 11/22/2006 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : SMALL /MED FAB
Previous Run : 29236A
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est:A 04.04.19 New issue KJ/JLM

Drawing Name : SUPPORT

Part Number : D32781
Drawing Number : D3278 REV. B
Project Number : N/A
Drawing Revision : B
Material : *N/A*
Due Date : 11/29/2006

Qty: *Split* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.2454 f(s)/Unit Total: 12.2693 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
(M6061T6B1.000x02.000)

Batch: *719295*
07/01/08

57-FA10565
was found
Scrapped
07/01/08

2.0 SHEAR *SAL* SHEAR

Comment: SHEAR
Cut blank: 2.00" x 1.00" x 2.550" long

07/01/08
06/12/05

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA405 and Dwg D3278
2- Deburr and Tumble
Identify as D3278-1

15F 07/01/09

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

15F 07/01/09

5.0 QC8 SECOND CHECK




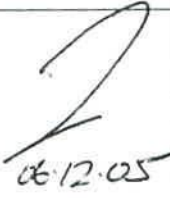

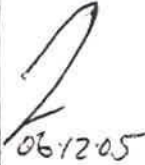
Comment: SECOND CHECK

07/01/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/11

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|--|---|-----------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/12/05 | 2 | Material was cut too long because it was identified wrong. S WAS missing on mat'l size |  | Material is no good for these supports. It is replace with correct mat'l. It is not correct material use for testing. | S G 06/12/05 |  06-12-05 |  07/01/06 |  06/12/05 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/22/2006 1:39:31 PM
User: Kilri Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 29647A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



20X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H / a.m

07/01/04

7.0

POWDER COATING

POWDER COATING



20X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-H / y/l

07/01/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 07/01/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/01/11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ml 07/01/11

Job Completion



U 07-01-11

| | | | |
|-----------------------|--------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 29647A |
| Description: Support | | Part Number: | D3278-1 |
| Inspection Dwg: D3278 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | .099 | ✓ | | | |
| 0.359 | +/-0.005 | .359 | ✓ | | | |
| 0.615 | +/-0.010 | | | | | |
| 0.250 | +/-0.010 | .251 | ✓ | | | |
| 1.480 | +/-0.005 | 1.480 | ✓ | | | |
| R0.125 | +/-0.010 | 0.125 | ✓ | | | |
| 0.119 | +0.005/-0.004 | .124 | | | | |
| 2.439 | +/-0.010 | 2.440 | ✓ | | | |
| | | | | | | |
| 1.980 | +/-0.010 | 1.985 | ✓ | | | |
| R0.130 | +/-0.010 | 0.130 | ✓ | | | |
| Ø0.257 | +0.005/-0.000 | .260 | ✓ | | | |
| R0.375 | +/-0.010 | 0.375 | ✓ | | | |
| 0.875 | +/-0.010 | .875 | ✓ | | | |
| 0.500 | +/-0.010 | .500 | ✓ | | | |
| R0.400 | +/-0.010 | 0.400 | ✓ | | | |
| | | | | | | |
| 1.720 | +/-0.010 | 1.722 | ✓ | | | |
| R0.125 | +/-0.010 | 0.125 | ✓ | | | |
| 0.125 | +/-0.010 | .130 | ✓ | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|-------------------|-------------------------|---------------------|-----|
| Measured by: J.L. | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 07/01/08 | Date: 07/01/08 | Date: | N/A |

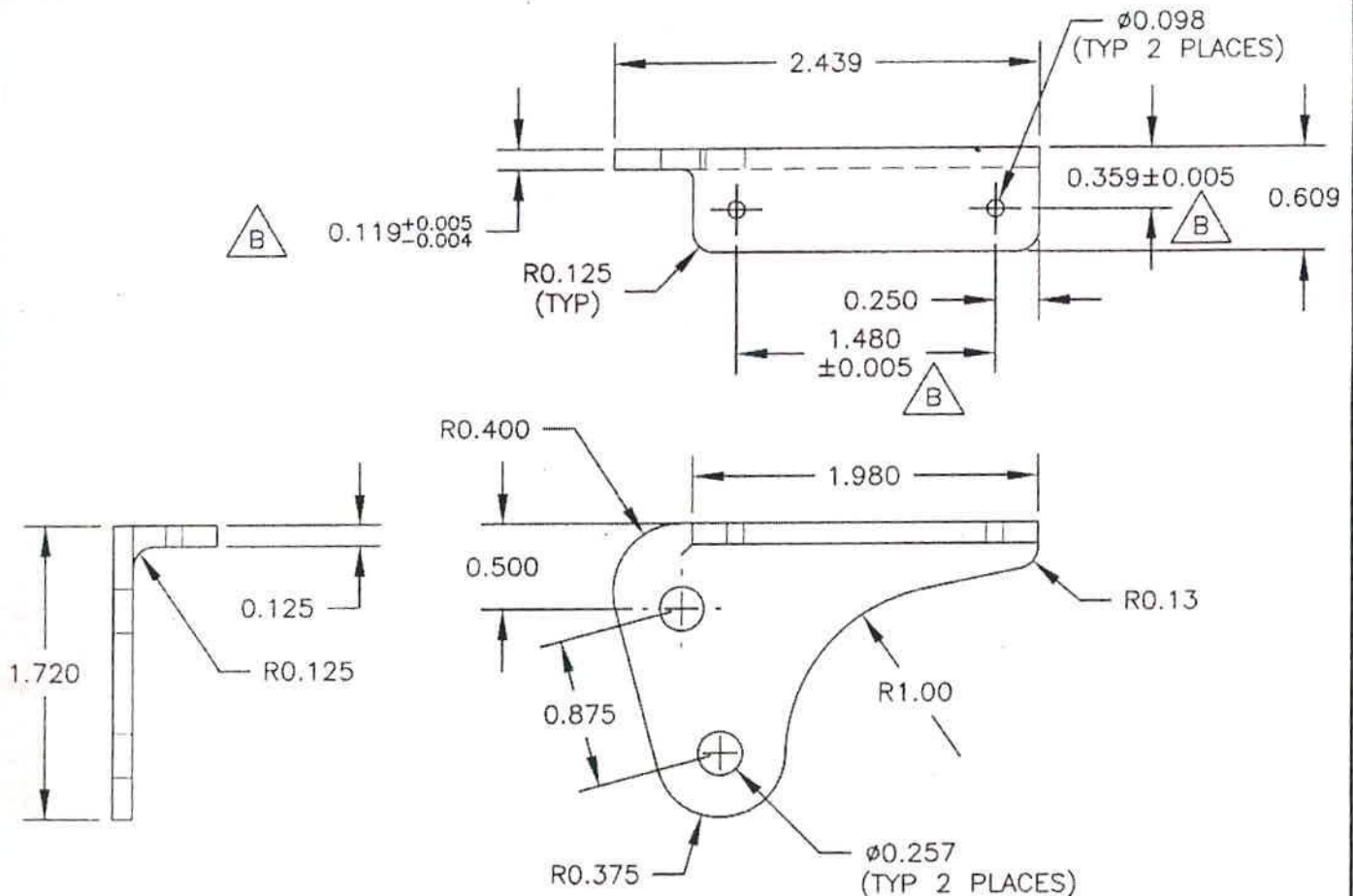
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|--------------------|-------------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM [Signature] | [Signature] |

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3278 | REV. B SHEET 2 OF 3 |
| DATE 05.03.31 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED

05-04-04



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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